

Work Order ID 139093

Friday, November 13, 2015 11:22:28 AM

139093

Shortage per order
Shortage for stock
Cut Feb 22-24 Page 1

Item ID: D4956-35 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Wearplate Aft
Start Date: 11/13/2015 Start Qty: 4.00 *4* 20
Required Date: 11/13/2015 Req'd Qty: 4.00 *4* 20
Reference: Cust Item ID:
Customer:

Approvals: Process Plan: MLS Date: NOV 16 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4956	A

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.01

(20)

2016/02/23

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

(20)

2016/02/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : _____																					

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(20)			DAS 38 9-89 FEB 24 2016
130 *130* Brake NC Brake NC	Form as per dwg Memo	0.00 0.00			DAS 30 9-89	20			FEB 24 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(20)			DAS 38 9-89 FEB 24 2016

DQA: _____ Date: _____



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 Start Date: 11/13/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/13/2015 Req'd Qty: 4.00 ***4*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							DAS 41 9-89
150						20			16-2-25
HandFinish	Memo	0.00							
Hand Finishing	1- After finish, coat entire top (concave) surface as per note 2 dwg D4956. TEXTURED COATING B#: <u>134278</u>								
160	QC3- Inspect Part Finish	0.00							DAS 38 9-89
160						(20)			FEB 26 2016
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00							
170						x20	f	16/02/2	
Packaging	Memo	0.00							
Packaging	LOCATION : FP002								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.01							
Quality Control									

_____ MJS _____ FEB 2 9 2016

MJS FEB 2 9 2016

DQA: _____ Date: _____



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Picklist Print

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Page 1

Work Order ID: 139093

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Parent Item: D4956-35

D4956-35

Parent Item Name: Wearplate Aft

Start Date: 11/13/2015

Required Date: 11/13/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

sf

151.8000

2.947368

M304S20GA

on 16/02/23

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

151.8

m132387

55.8

m133511

96

10.5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

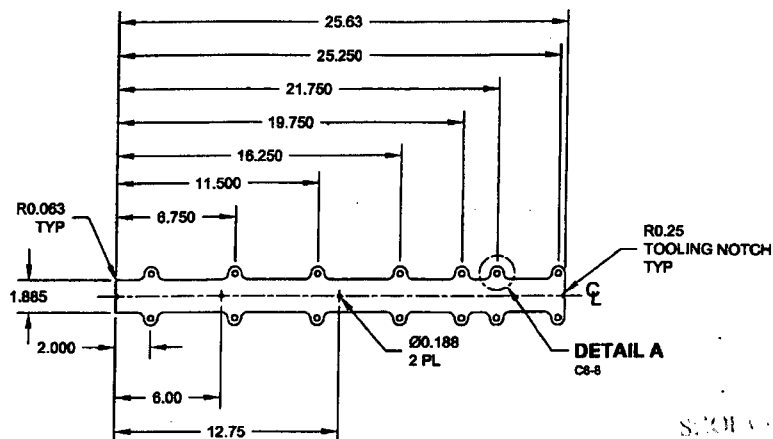
QA Closed: _____ Date: _____

Work Order update only ☐

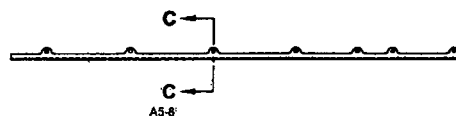
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																																																			
Description Work Order Deviation			Disposition																																																																				
					Completed By																																																																		
					Lead hand / Supervisor Approval Verification																																																																		
					QC / QA Coordinator Approval																																																																		
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OTHER : _____																																																																							

FIRST ARTICLE INSPECTION CHECKLIST

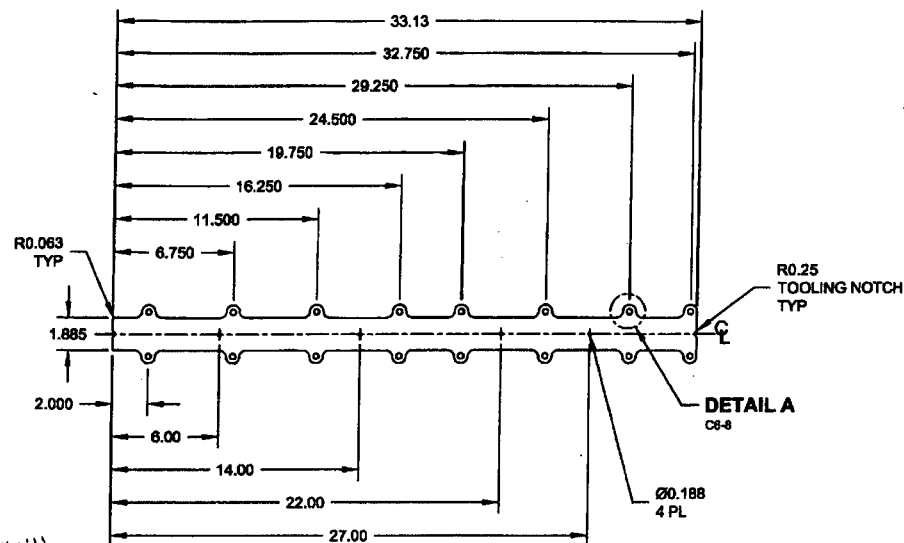
Measured by: <i>DC</i>		Audited by: 38		Preliminary Approval:	
Date: <i>16/02/23</i>		Date: 9-88		Date:	
FEB 24 2016					
Rev	Date	Change			Revised by
A	14.10.23	New Issue			KJ <i>[Signature]</i>
					Approved <i>[Signature]</i>



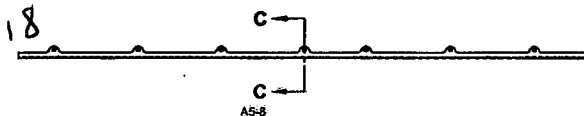
D4956-35F FLAT PATTERN



D4956-35 WEARSHOE
(MAKE FROM D4956-35F)



D4956-37F FLAT PATTERN



D4956-37 WEARSHOE
(MAKE FROM D4956-37F)

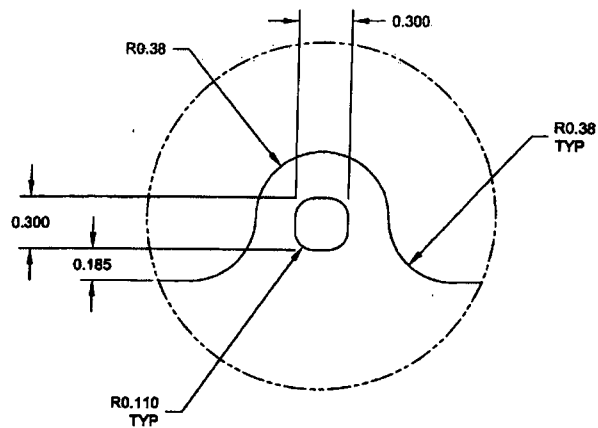
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.038 THICK (20 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4956-35 = 0.60 lbs; D4956-37 = 0.76 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

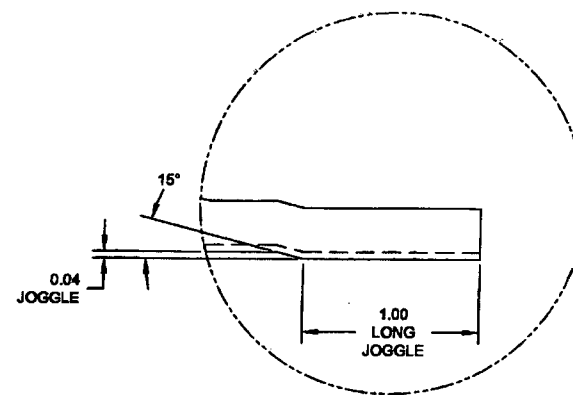
DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D4956 SHEET 6 OF 8
APPROVED		TITLE SCALE
DE APPR.		WEARSHOE NTS
DATE	13.09.26	

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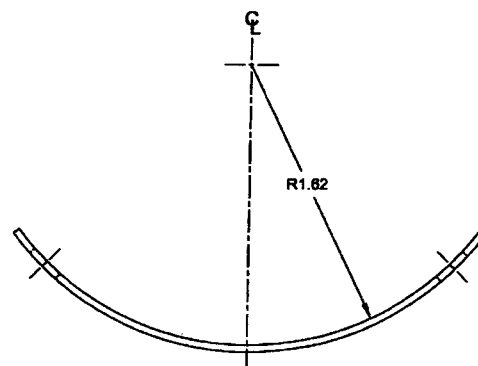
RELEASED
2014-04-17



DETAIL A C8-1 C4-1
C8-2
C8-3 C1-3
C2-4
C8-5 C2-6
C8-6 C2-8
C4-7 C3-7



DETAIL B B6-1 B2-1
B3-2
B6-3 B1-3
B2-4
B4-7 B1-7



SECTION C-C B7-1 B3-1
B5-2
B7-3 B3-3
B8-4
B7-5 B3-6
B7-6 B3-8
B7-7 B3-7

RELEASED
2014-04-17
AMP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	NS	D4956	SHEET 8 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEARSHOE	NTS
DATE	13.09.26	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE COPIED FOR ANY PURPOSES OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	